

Work Order ID 161437 -2

161437

Page 1

Tuesday, May 16, 2017 10:20:22 AM

Item ID: D412-711-101

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Replacement Vertical Reference Window

Start Date: 5/16/2017 Start Qty: 4.00

4

2

Cust Item ID:

Required Date: 5/23/2017 Req'd Qty: 4.00

4

Customer:

Reference: SCHEDULED

Approvals: Process Plan:

DAS

21

Date: MAY 16 2017

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D412-711-101

C

DAS

6

9-89

JUN 05 2017

100

Document Control

0.00

100

DC

Doc.Control -USB or Paperwork

Memo

0.00

Photocopy bluefiles and create labels
for PPP D412-711-101 Change 002

2

DAS

28

9-89

JUN 06 2017

110

0.00

110

HandThermo

Hand Finishing Thermoforming

HAND FINISHING THERMOFORMING

Memo

1.44

Set up Machine as per folio FTA 077 and D711W program using mould DT9640

3

17/05/17

DAS

07

9-89

120

0.00

120

HandThermo

Hand Finishing Thermoforming

HAND FINISHING THERMOFORMING

Memo

1.56

Cut Blanks to 37.5" by 43"

3

17/05/17

DAS

07

9-89

Work Order ID 161437

Tuesday, May 16, 2017 10:20:22 AM

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Page 2

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Stop ***NS2***

Item Name: Replacement Vertical Reference Window

Start Date: 5/16/2017 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 5/23/2017 Req'd Qty: 4.00 ***4***

Customer:

Reference: SCHEDULED

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	THERMOFORMING MACHINE								
Thermoform	Memo	3.12							
Thermoforming Machine	Thermoform as per Dwg. D412-711-101 using DT 9640 and Folio FTA 077								
	Dwg. Rev. <u>C</u>								
	Folio Rev. <u>D</u>								
	Visually inspect for proper formation and clarity								
	Visually and inspect magic eye								
	Verified by: _____								
160		0.00							
160	HAND FINISHING THERMOFORMING								
HandThermo	Memo	4.76							
Hand Finishing Thermoforming	1) Trim off excess flange material 2) Buff out any light scratches or 3) Etch part number and batch number								

DAS
07
9-89

17/05/17

17/06/01

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Page 4

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Cust Item ID:

Required Date: 5/23/2017 Req'd Qty: 4.00 ***4***

Customer:

Reference: SCHEDULED

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: _____	0.00							
190									
Packaging	Memo	0.04				2	DAS 27 9-89		
Packaging	Location : FG099								
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.40							
Quality Control									

JUN 07 2017

17/6/12

DAS
21
9-89

JUN 07 2017

Picklist Print

Tuesday, May 16, 2017 10:20:26 AM

Page 1

Work Order ID: 161437

Parent Item: D412-711-101

Parent Item Name: Replacement Vertical Reference Window

Start Date: 5/16/2017

Required Date: 5/23/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 06-02-01 JLM
10/06/28 DL

IPP Rev. B. Manufacture in-house

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status DAS
MACRLICS.236 Plexiglass G 0.236"		Purchased	No			110	sf	231.6604	16	85.333333			07 9-89

Location

Loc Qty

Loc Code

therm

231.6603688

M134733

30.9089733

M135485

0.0009155

M135775

19.41748

M135914

117.333

M137404

64

64 sg pt.

17/05/17

DART AEROSPACE LTD		Work Order: 161437
Description: Replacement Window		Part Number: D412-711-101
Inspection Dwg: D412-711-101	Rev: <i>pc oh</i>	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <i>N/A</i> "				
Shape Definition	<i>✓</i>			
Texture Retention	<i>✓</i>			
Material imperfections such as bumps, cracks, voids, scratching	<i>✓</i>			

Measured by: <i>DAS</i> <i>07</i> <i>9-89</i>	Date: 17/05/17
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.00	+/-0.030	<i>2.03"</i>				
<i>1.98 N/A</i>	+/-0.030					
1.50	Min	<i>1.52"</i>	<i>✓</i>			
<i>0.076" 0.090</i>	Min	<i>0.072"</i>	<i>✓</i>			
<i>0.065" 0.070</i>	Min	<i>0.085"</i>	<i>✓</i>			
<i>0.046" 0.050</i>	Min	<i>0.068"</i>	<i>✓</i>			
15.0	+/-0.5	<i>14.625"</i>	<i>✓</i>			

Measured by: <i>DAS</i> <i>07</i> <i>9-89</i>	Date: 17/06/01
Audited by: <i>RB</i>	Date: 17-06-02
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
B	10.10.08	New Issue	KJ	
C	13.06.03	Dimensions updated per Dwg Rev B	KJ <i>[Signature]</i>	<i>MA</i>

△ MIN THICKNESS = 0.046
EXCEPT WHERE SHOWN

△ MIN THICKNESS = 0.065
THIS FACE & REGION ONLY

△ MIN THICKNESS = 0.076
THIS FACE & REGION ONLY

7.2
MIN THICKNESS = 0.043 △

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. *161437*

1.50
MIN FLANGE

170516

△ MIN THICKNESS = 0.052
EXCEPT WHERE SHOWN

5.0

0.236
REF

MAX DEPTH
15.0±0.5

NOTES:

1) MATERIAL: PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C
OR POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425,
0.236 THICK (STOCK, REF. DART SPEC. M-ACRYLIC-S.236)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: ENGRAVE P/N "D412-711-101" & B/N "BXXXX" ON THE INSIDE SURFACE
OF THE BUBBLE WINDOW FLANGE, WITHIN 0.25" OF BUBBLE. USE 0.125" LETTERS TO MAX. DEPTH OF 0.005"

7) WEIGHT: 8.0 lbs

8) VACUUM FORMING: PER FOLIO FTA077 USING DT9640 MOLD AND DART QSI 022

D412-711-101 REPLACEMENT WINDOW

RELEASED
2017-02-07
EN 17-512

C	CHG WALL DIMS PER TR-D412-711-1 REV. B	CP	16.04.21
B	REMOVED 1.73" DIM (ZN B4-1). SEE PREVIOUS REV. FOR DETAILS. 2.00 WAS 1.98 (ZN B3-1) REF CIR12-6	SFM	12.12.24
A	NEW ISSUE	MB	10.08.28
REV.		DESCRIPTION	
BY		DATE	
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED	N/D	DRAWING NO.	REV. C
MFG. APPR.	IS	D412-711-101	SHEET 1 OF 1
APPROVED	CH	TITLE	SCALE
DE APPR.	TH	REPLACEMENT WINDOW	NTS
DATE	16.04.21	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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Approvals: Process Plan: DAS 21 Date: MAY 16 2017QC: 9-89 Date:

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Run Start *NR1*

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Draw Nbr

Revision Nbr

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for PPP D412-711-101 Change 002

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